



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4680-041-BENT
Job Sheet 202086



Part No: D4680-041-BENT

Job Qty: 6 pcs

Part Name: Extrusion Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/25/19

Description:

Note: DWG D4680 REV.G IPP REV:A 16.05.16 NEW ISSUE DD VERF:JLM IPP REV:B 19.09.18 AS PER DWG REV.G DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	6 pcs	11/25/19	11/25/19	0.00	1.67	Skidtubes - Bend		<i>MACA</i>
120	QC 5	6 pcs	11/25/19	11/25/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BP</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	6 pcs	11/25/19	11/25/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		



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CANADA
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Email: sales@dartaero.com
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Container No: S227302



Part: D4680-041-BENT

Job No: 202086

Serial No/Batch: S227302

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

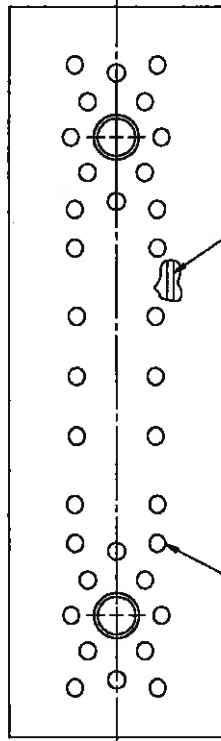
Date: 10/28/19

				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B	BC				
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - SA	6 pcs	11/25/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9:50
								QC 21 - SA - 70	
								QC 21 - SA - 53	
				Part Op 110 - (CNC Delta 100 Bender), 1- Bend as per dwg D4680 using bend program D4680 and Folio: 26 ***Verify Descriptions: mesurement before cutting.*** 2- Cut FWD end as per dwg D4680 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>L602</u>) 140 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				D2962-150	3.540 Outer Tube, Extrut	6 pcs (1 ea)	110-Skidtubes - Bend - 1	S175497	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
				110-Skidtubes - Bend - 1	D2962-150	6	48	0	
Part Specifications									
Specifications could not be found.									

Plex 10/18/19 10:34 AM Dart.lajeunesse.marie

1 2 3 4 5 6 7 8

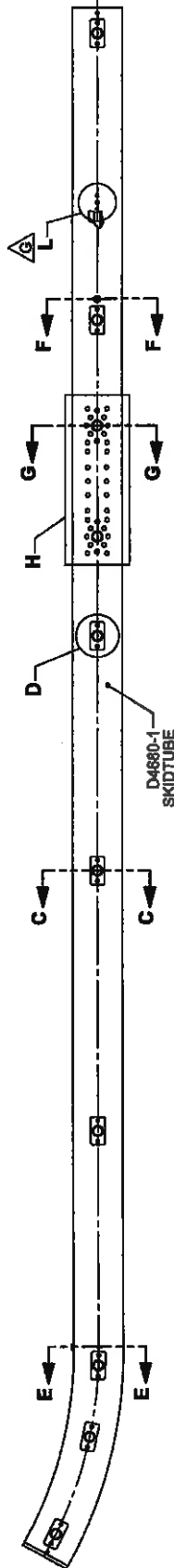
QTY	PIN	DESCRIPTION
1	D4680-043	SKIDTUBE SUB ASSY
1	D4680-1	SKIDTUBE
1	D4681-041	WEB ASSY
8	D4688-1	SPACER
16	D4753-1	DOUBLER
2	D6304-1	CROSSBOLT SPACER
2	D6520-1	DOUBLER
3	AELS-1032-130	INSERT
3	AN304A	BOLT
4	CR1122-3-02.5	RIVET
88	CR3212-5-05	CSK RIVET, CHERRY MAX
32	MS20601AD4W3	RIVET, BLIND, CSK
2	MS21D48L4	NUTPLATE
3	NAS1148C0332R	WASHER



12 CR3212-5-05
CSK RIVET, CHERRY MAX
34 PL PER DOUBLER

10

11



D4680-043 SKIDTUBE SUB ASSY

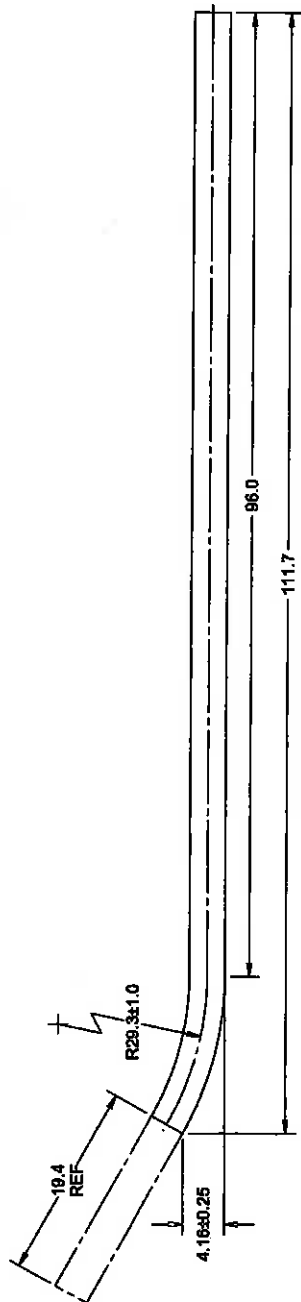
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (REF 4.3.5.1) PER DART OSI 005 4.3
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 18.9 lbs
 - 8) SEAL ALL MATING SURFACES USING PROSEAL 880/422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -2411-287 ADHESIVE PER DART OSI 015
 - 10) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER
 - 11) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS
 - 12) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

RELEASED
2019 SEP 10 10

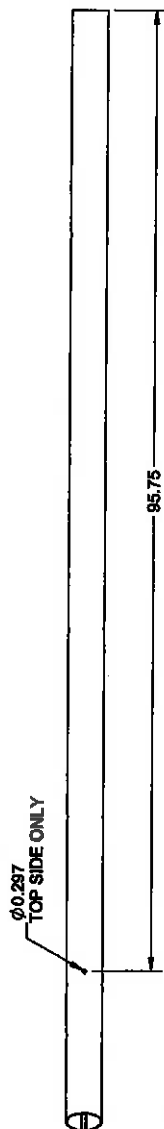
APPROVED

DESIGN	AP	AP	DESIGN NO.	REV. G
DRAWN	ZF	MW	D4680	SHEET 3 OF 8
CHECKED		DD		SCALE
APPROVED		NO		NTS
DATE	19.03.28			

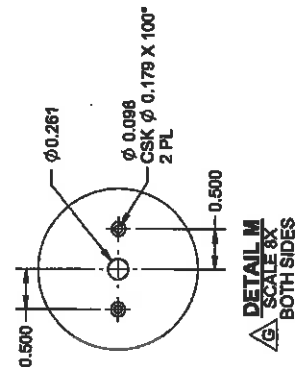
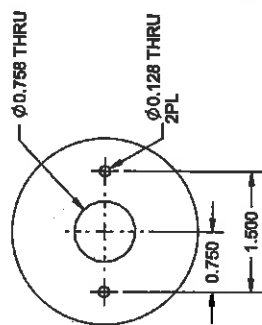
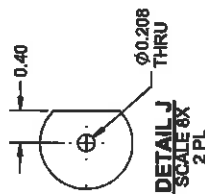
SKIDTUBE
DART AEROSPACE USA, INC.
HILLSBORO, OR



D4680-1 SKIDTUBE BENDING/TRIMMING DETAIL



D4680-1 SKIDTUBE DRILLING DETAIL



- NOTES:
- 1) MATERIAL: MAKE FROM D2962-150 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 11.36 lbs

RELEASED
2019 SEP 10 16

APPROVED

DESIGN	AP	19.03.28
DRAWN	ZF	
CHECKED	MW	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DO	
DATE		19.03.28

DART AEROSPACE USA, INC.
HILLSBORO, OR

D4680
REV. G
SHEET 5 OF 5

SKIDTUBE
SCALE
NTS

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ Machining ☐ ☐ Large Fab ☐ ☐ Cross tube ☐ ☐ Small Fab ☐ ☐ Finishing ☐ ☐ Eng. (Non-AW) ☐ ☐ Prod. Eng. Coord. ☐ ☐ Rec/Store/Packaging ☐ ☐ Engineering ☐ ☐ Water Jet ☐ ☐ Supplier Quality ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____											